

Work Order ID 64952

Page 1

Tuesday, January 04, 2011 3:08:54 PM

Item ID: D350-636-016

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube STD w/ Training Wearplates, RH

Start Date: 1/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*RL*Date: *1-01-11*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4168

A

IIN-D350-636

H

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-016 CHG 001

*Sub 01/24**OK Per ch 1/10/21***B64952**

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110



Skidtubes

Skidtubes

.Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D41683- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr.4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade
fitting5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as
per dwg D41686- Drill pilot holes as per Dwg D4168 sheet 5 (D4168-1 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)7- Clecko DT8863B on second side of tube and drill pilot holes for detail K.
SECOND SIDE8-Open up holes for Detail K to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D4168. Open up
holes for ground handling and detail C to 0.500" (8 holes per side)9-Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201 iplace per
side

10-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left

11.01.07
perm. change

DT8983

1 0 BE 11/01/07

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

from bending as per QSI 004

A/R Aluminum Rod batch: M115778

11-Grind welds flush as per Dwg D4168

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/10

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/10

Memo

0.00

40

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool#

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 BE 11/10/10

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Sub 1/10

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Reference:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes		0.00							
Skidtubes	<p>Memo</p> <p>1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.</p> <p>2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168.</p> <p>3- Open float hole to 0.500" (4 per side)</p> <p>4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9)</p> <p>5-Deburr and blow out all chips from inside of tube</p> <p>6- Prepare tube for welding, remove alodine as required.</p> <p>7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/><input type="checkbox"/><input type="checkbox"/> Sikaflex-291 batch <u>M116040</u> <input type="checkbox"/><input type="checkbox"/><input type="checkbox"/> exp. date: <u>09/2011</u></p> <p>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R <input type="checkbox"/><input type="checkbox"/><input type="checkbox"/> Aluminum Rod batch: <u>M116577</u></p> <p>9- At section AP-AP drill out x-bolt spacer to 0.404"</p> <p>10-Grind welds flush as per Dwg D4168</p>								

BE 11/01/11

BE 11/01/17

BE 11/01/17
BE 11/01/18

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D4168

12- C'bore section CH-CH

13- Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Memo

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

=> M 11/6/11 19



HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 / 0

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 115951



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:10
OVEN TEMPERATURE: 320°
FINISH TIME: 10:40

1 / BL 11-01-20.

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

✓ Inspect for foreign object per QSI 024

=> M 11/01/20

1 / 0

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinishing

⇒ Ml 11/01/20

HandFinish

Memo

0.00

Hand Finishing

✓ Install inserts as per Dwg D4168

1 0

230

0.00



HandFinishing

⇒ Ml 11/01/20

HandFinish

Memo

0.00

Hand Finishing

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168

SIKA FLEX 241

BATCH: 1115114EXP DATE: 11161

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

✓ A/R 55-o'ring lube batch: M114189✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: M114596

1 0

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulal21

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

1/1/21

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulal24

*****ensure antiseize is on AN8C21A bolts*****

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-636-016

Location: 72PPP rev: A

11/1/24
S
D

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

CK 11/01/24

MF
11-01-24

Picklist Print

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10

Work Order ID: 64952

Parent Item: D350-636-016

Parent Item Name: Skidtube STD w/ Training Wearplates, RH




Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3490-1  Cross Bolt Spacer		Manufactured	No			160	Each	89.0000	4	4		BEH/01/17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		89							
				59424		3							
				62450		56							
				64005		30							
D3490-3  Cross Bolt Spacer		Manufactured	No			160	Each	59.0000	4	4		BEH/01/17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		59							
				60294		1							
				62668		6							
				63556		30							
				64006		22							
AN3C34A  BOLT		Purchased	No			230	Each	80.0000	1	1		11/01/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST353		80							
				115767		10							
				116003		20							
				116075		50							

Picklist Print

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Purchased

No

230

Each

141.0000

4

4



BOLT



11/10/120

Location

Loc Qty

Loc Code

ST353

141

109771

6

116050

50

116239

10

116381

70

116522

5

X4

AN3C37A

Purchased

No

230

Each

65.0000

1



BOLT



11/1/121

Location

Loc Qty

Loc Code

ST353

25

114801

1

115908

24

ST354

40

116381

20

116523

20

1

AN3C42A

Purchased

No

230

Each

97.0000

1



BOLT



11/1/121

Location

Loc Qty

Loc Code

ST354

97

106176

97

1

Picklist Print

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

15.0000

1

1



Blade Fitting Assembly, RH



xl 1/10/20

Location

Loc Qty

Loc Code

FP008

14

59643

4

62003

10

FP18

1

61690

1

D3873-1

Manufactured No

230

Each

273.0000

7

7



Bushing



xl 1/10/20

Location

Loc Qty

Loc Code

ST089

100

64567

100

ST092

170

62197

40

63314

30

64760

100

ST093

3

57615

3

D4154-041

Manufactured No

230

Each

0.0000

1

1



Wearplate Assembly



xl 1/10/20

PTO =>

Picklist Print

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4170-1 Manufactured No

230 Each

27.0000

4

4



Bushing



BE 1/21/17

Location

Loc Qty

Loc Code

LG

27

62251

4

62669

1

63322

22

4

D4171-1 Manufactured No

230 Each

11.0000

1

1



Bushing



11/01/20

Location

Loc Qty

Loc Code

ST135

11

62710

11

x1

MS21043-3 Purchased No

230 Each

1,731.000

5

5



Nut



11/01/20

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1655

112314

1655

x5

NAS1149C0363R Purchased No

230 Each

5,568.000

9

9



Washer



11/01/20

Location

Loc Qty

Loc Code

ST297

5568

113524

46

113644

22

113889

500

114742

5000

x9

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Shop Packet Print

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

340.0000

4

4



WASHER



11/10/120

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

300

111819

66

113362

234

YU

AN960JD816

Purchased

No

250

Each

105.0000

2



1/2" washer, Alum



11/12/18

Location

Loc Qty

Loc Code

ST348

105

106043

105

Z

D2744

Manufactured

No

110

Each

32.0000

1



Cap



BE 11/01/07

Location

Loc Qty

Loc Code

ST

32

62715

32

I

D2600-3-BENT

Manufactured

No

110

Each

14.0000

1



Extrusion Bent



BE 11/01/07

Location

Loc Qty

Loc Code

LG

14

61634

4

62764

1

64434

9

I

Picklist Print

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

170.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

170

50281

10

57953

2

59111

10

61844

64

64003

84



BE 1/10/17

D2739

Manufactured No

160

Each

13.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

13

62688

3

64448

10



BE 1/10/17

ALS4-1032-225

Purchased No

230

Each

4,124.000

4

4



Insert

Location

Loc Qty

Loc Code

PK011

4124

110768

4124



HL 1/10/120

D3492-041

Manufactured No

230

Each

97.0000

8

8



Plug Assembly

Location

Loc Qty

Loc Code

FP013

97

59114

1

62210

3

63994

93



HL 1/10/120 PTO=7

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

44.0000

1

1



BOLT



11/01/20

Location

Loc Qty

Loc Code

ST346

44

114442

5

115188

13

115960

26

Y1

AN6C44A

Purchased

No

230

Each

79.0000

4

4



BOLT



11/01/20

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

77

111649

2

114653

1

114941

24

115936

50

X4

MS21083C8

Purchased

No

230

Each

67.0000

1

1



NUT



11/01/20

Location

Loc Qty

Loc Code

ST303

67

113845

5

114934

3

115594

4

115884

46

116289

9

Y1

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No

230 Each 201.0000 8 8



Washer



11/01/20

Location

Loc Qty

Loc Code

ST072

201

60755

9

63647

192

x8

AN960C10L NAS1149C0332 Purchased No

230 Each 25.0000 4 4

R



washer

11/16/025



x4 11/01/20

Location

Loc Qty

Loc Code

ST245

25

107534

25

D2745 Manufactured No

230 Each 185.0000 8 8



Bushing



11/01/20

Location

Loc Qty

Loc Code

ST023

185

52311

5

59112

4

61988

68

63315

108

x8

AN960C816L NAS1149C08332 Purchased

No *

230 Each 0.0000 1 1



WASHER



x1 11/14/15 11/01/20

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

230

Each

65.0000

8

8



Plug Assembly

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

63

59117

1

59190

4

63996

58

AN3C6A

Purchased

No

230

Each

241.0000

4

4



BOLT

Location

Loc Qty

Loc Code

ST351

241

111982

166

116419

75

MS21043-6

Purchased

No

230

Each

578.0000

4

4



NUT

Location

Loc Qty

Loc Code

ST301

578

112314

578

D3493-1

Manufactured

No

250

Each

16.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST062

16

61672

16

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Start Date: 1/4/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

67.0000

1

2



NUT



11/12/11

Location

Loc Qty

Loc Code

ST303

67

113845

5

114934

3

115594

4

115884

46

116289

9

AN8C21A

Purchased

No

250

Each

87.0000

2

2



BOLT



11/12/11

Location

Loc Qty

Loc Code

ST345

87

113558

1

114653

2

115723

24

116381

60

D2741

Manufactured

No

250

Each

47.0000

1

1



Blade, 350 Skidtube



11/12/11

Location

Loc Qty

Loc Code

ST466

47

60210

12

61341

35

W/O:..		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
16/01/20	230	<u>Plug Assembly</u> Assemble with D2594-3 "O" rings! M61762	el	16/01/20	x5		S 16/01/21	
11/01/20	230	Plug Assembly Assemble with NAS1611-013/M1116582 "O" rings	el	11/01/20	x8		S 16/01/21	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

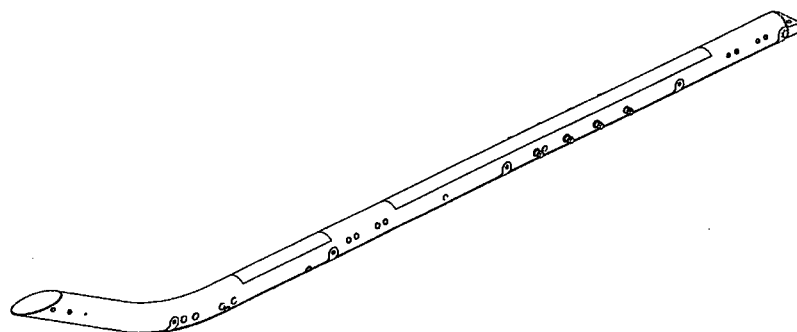
- 1) MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHC
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ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 04952

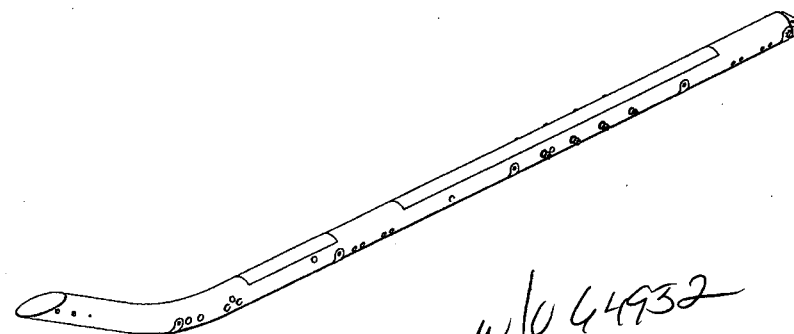
11-01-4

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2010-09-15

A	NEW ISSUE	DESCRIPTION	SC	10.08.09
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		PORT HADLOCK, WA		
DRAWN	SC	DRAWING NO.	REV. A	
CHECKED		D4168		
MF.G. APPR.			SHEET 1 OF 11	
APPROVED		TITLE	SCALE	
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS	
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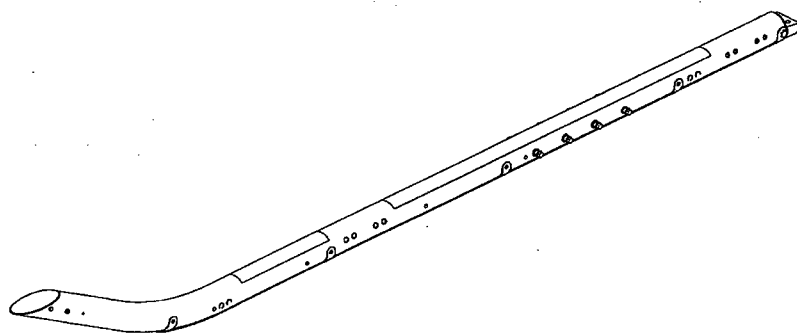
D4168-041 350 SKIDTUBE ASSEMBLY, LH



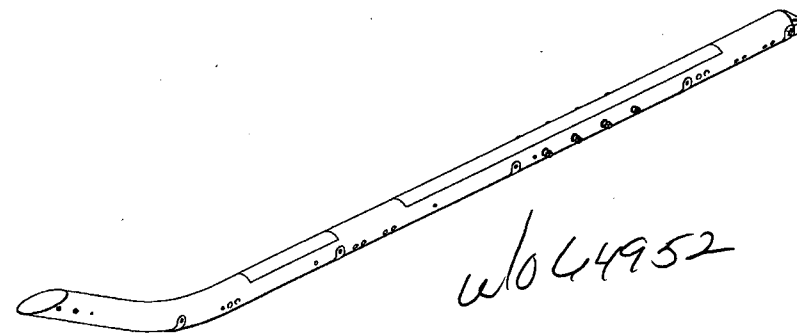
D4168-042 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
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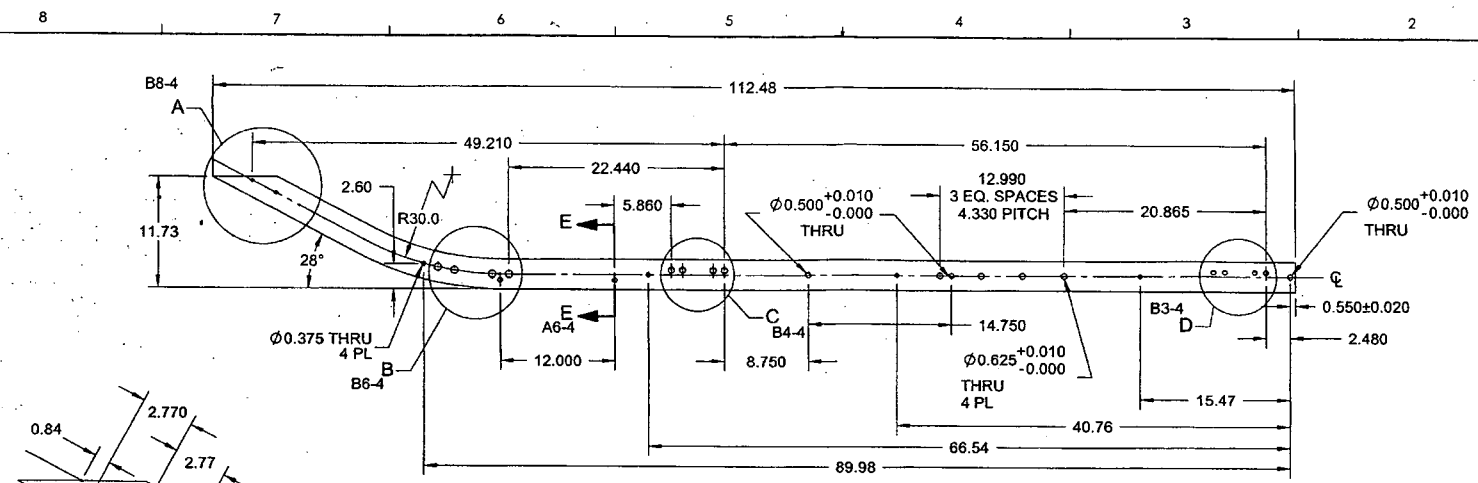
D4168-043 350 SKIDTUBE ASSEMBLY, LH



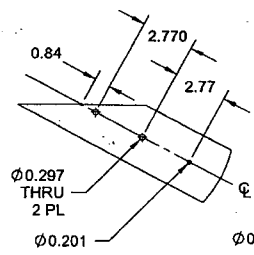
D4168-044 350 SKIDTUBE ASSEMBLY, RH

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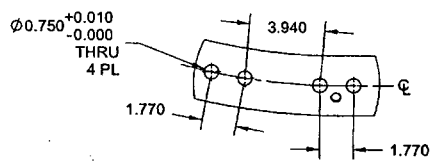
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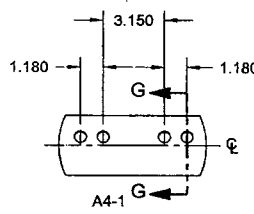
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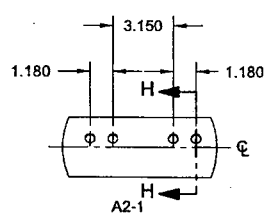
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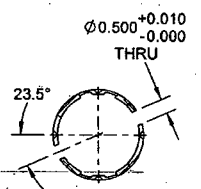
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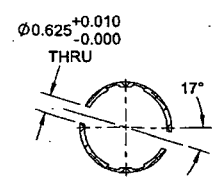
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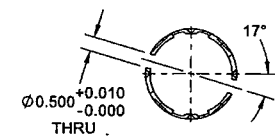
DETAIL D
SCALE 2X



SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL

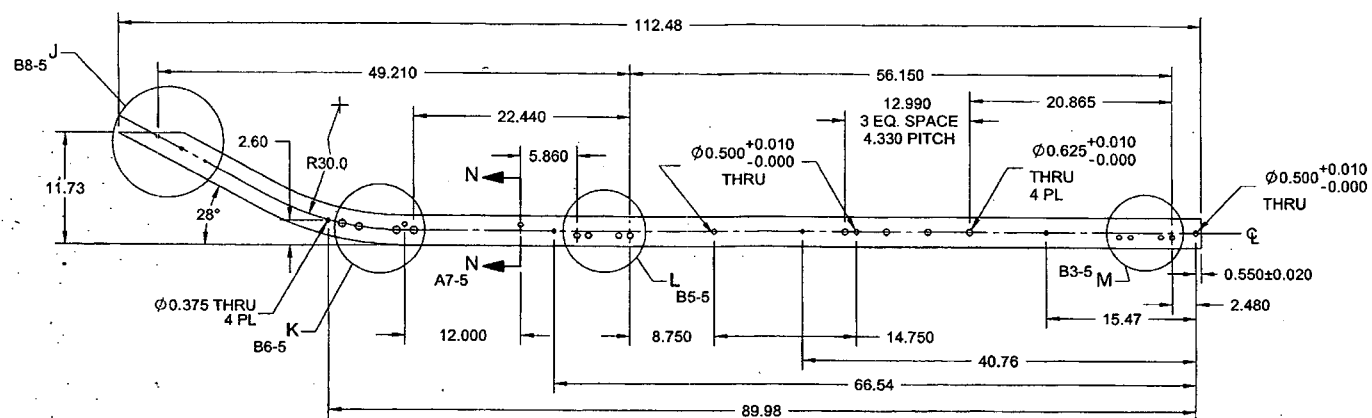


SECTION H-H
SCALE 3X, 4 PL

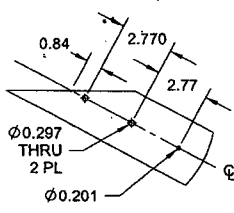
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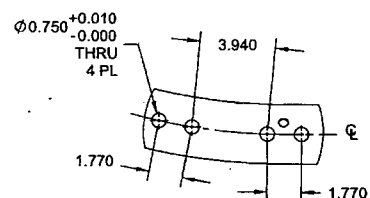
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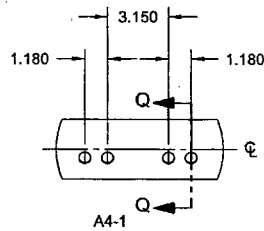
D4168-2 RH SKIDTUBE



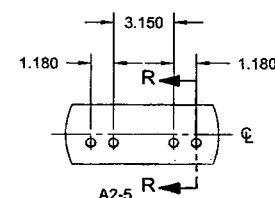
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SCALE 2X



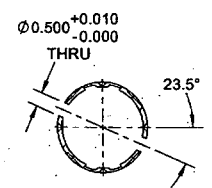
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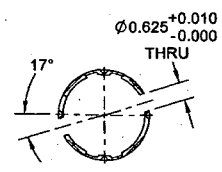
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SCALE 2X



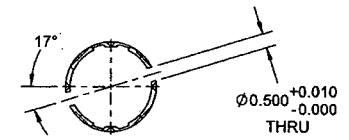
DETAIL M
SCALE 2X



SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL

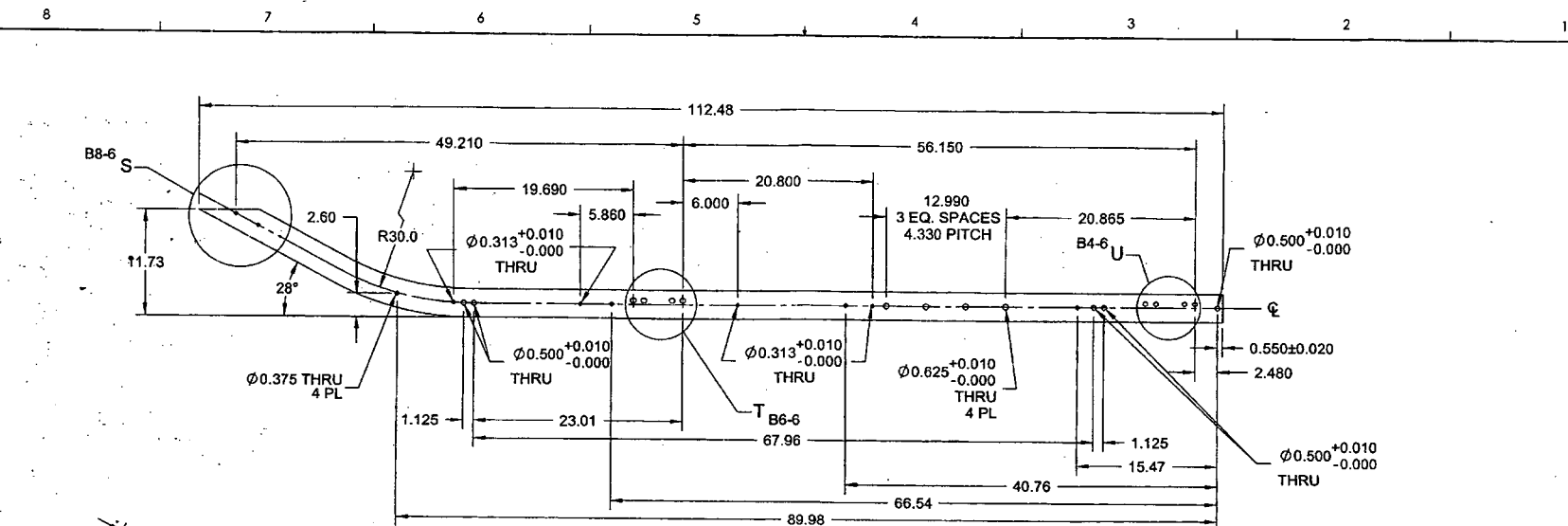


SECTION R-R
SCALE 3X, 4 PL

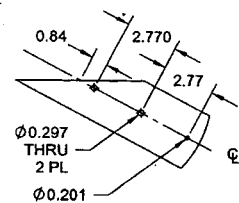
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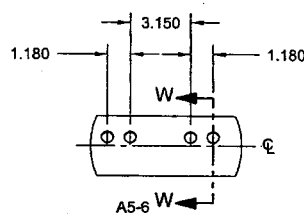
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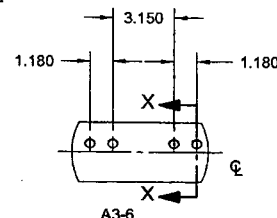
D4168-3 LH SKIDTUBE



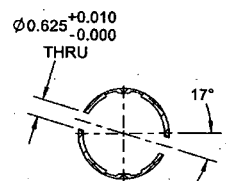
DETAIL S
SCALE 2X



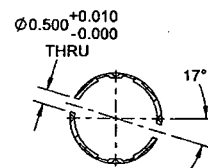
DETAIL T
SCALE 2X



DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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D

D

C

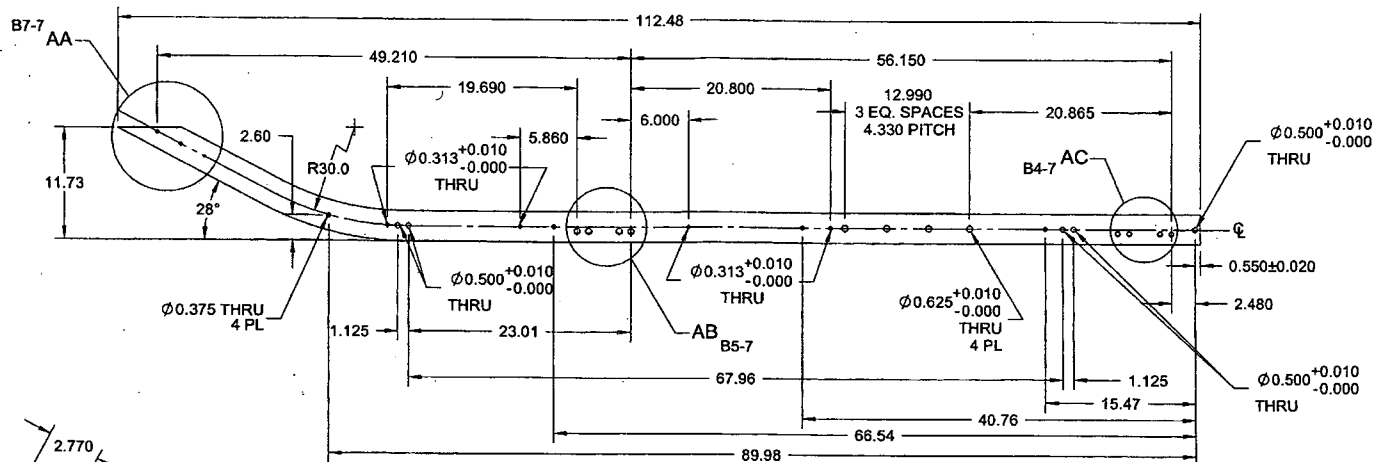
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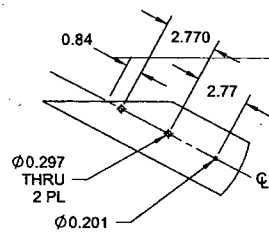
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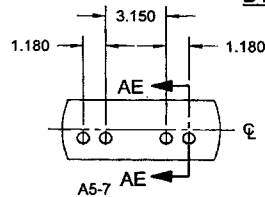
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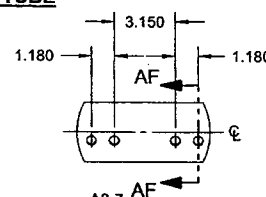
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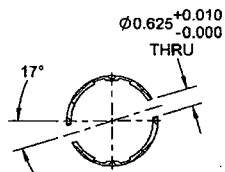
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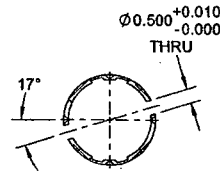
DETAIL AB
SCALE 2X



DETAIL AC
SCALE 2X



SECTION AE-AE
SCALE 3X, 4 PL



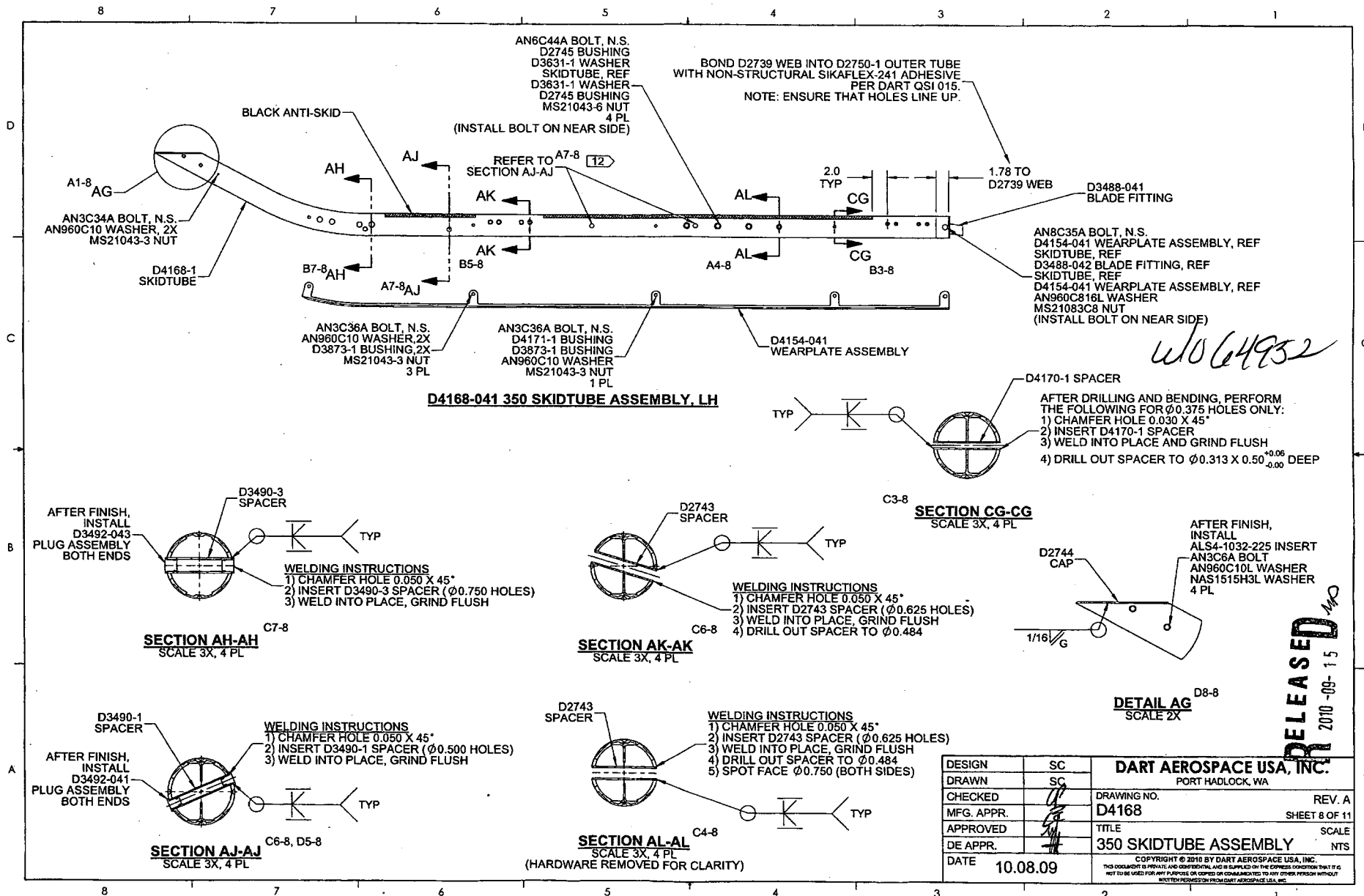
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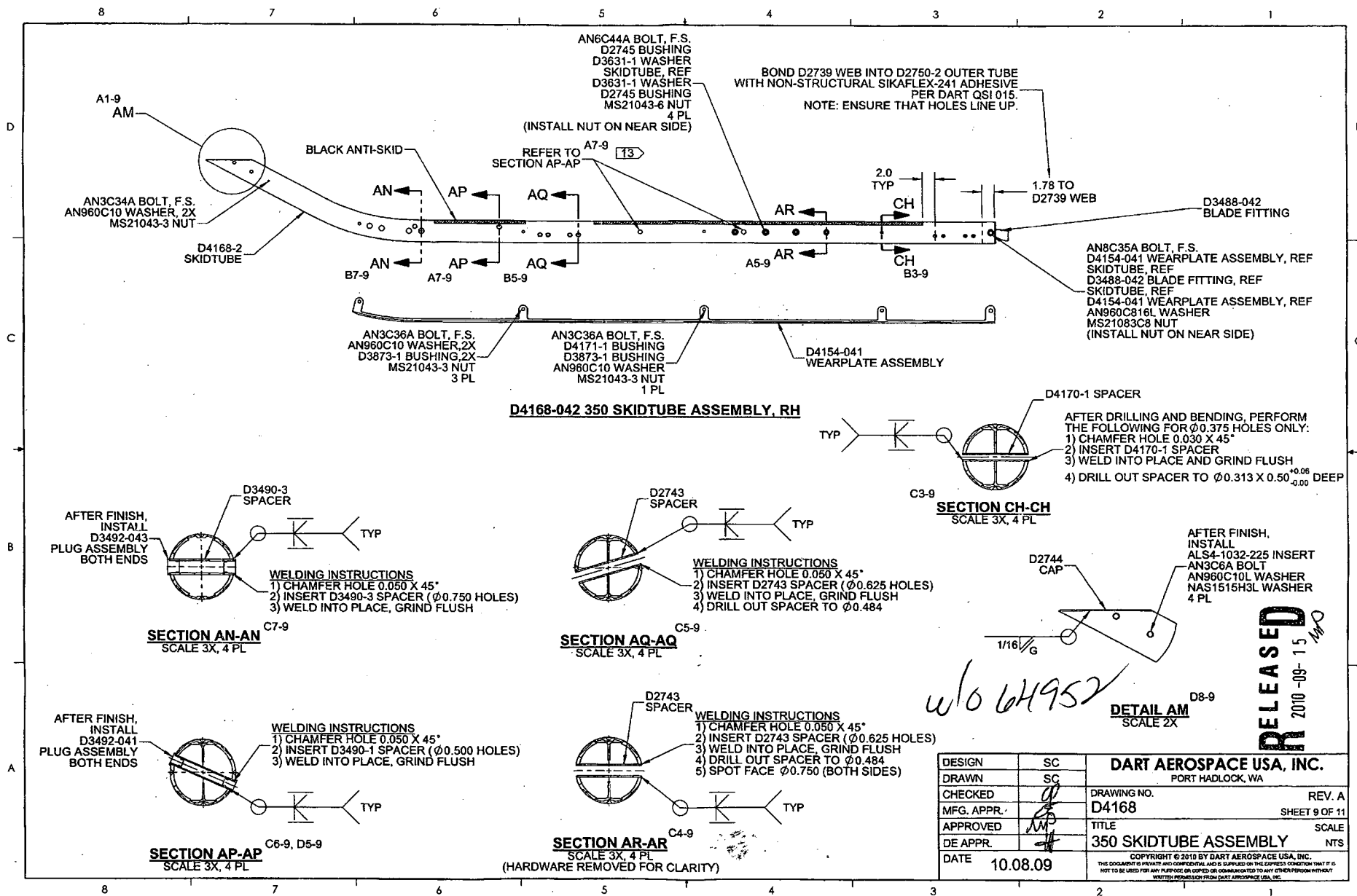
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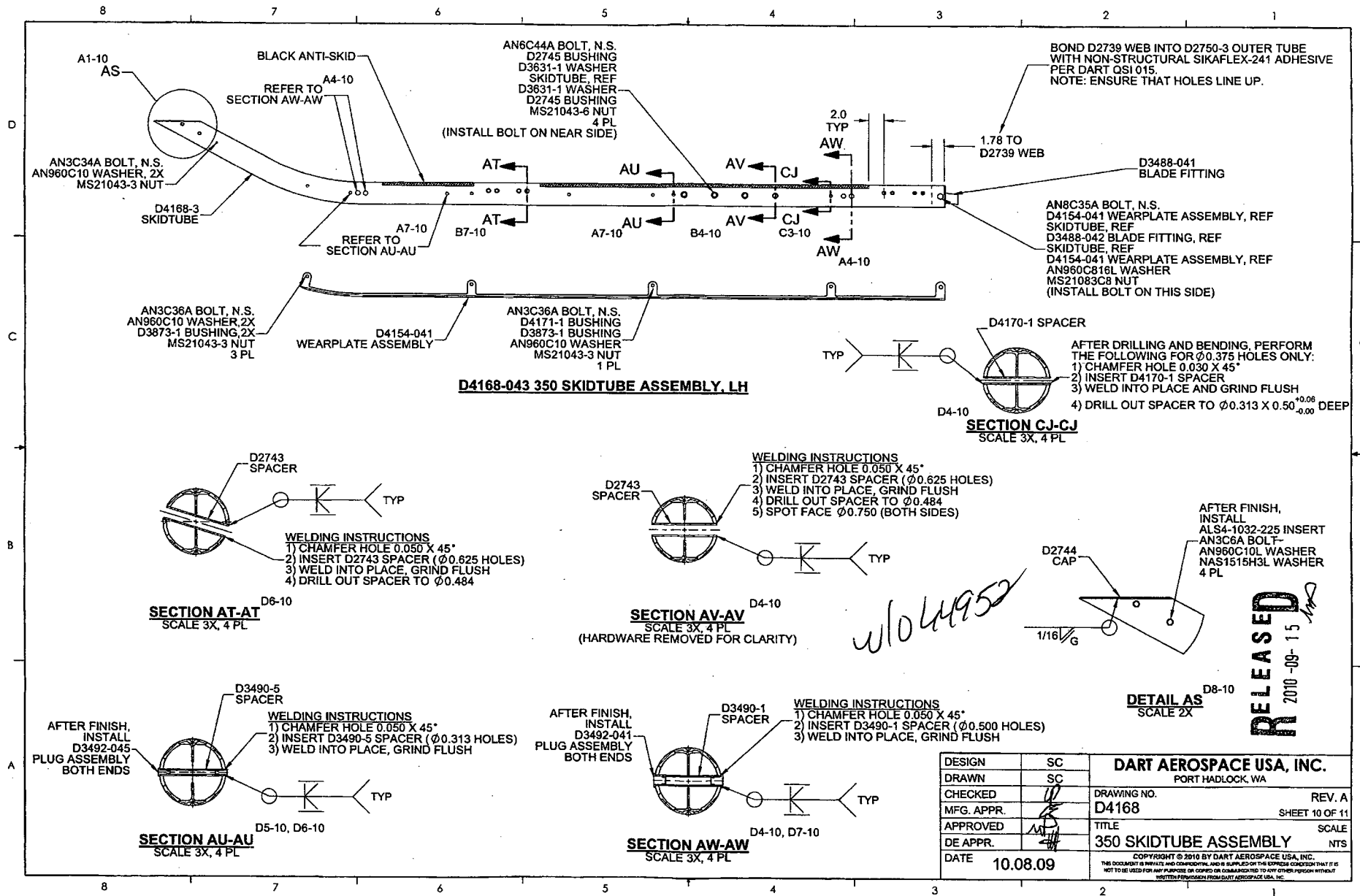
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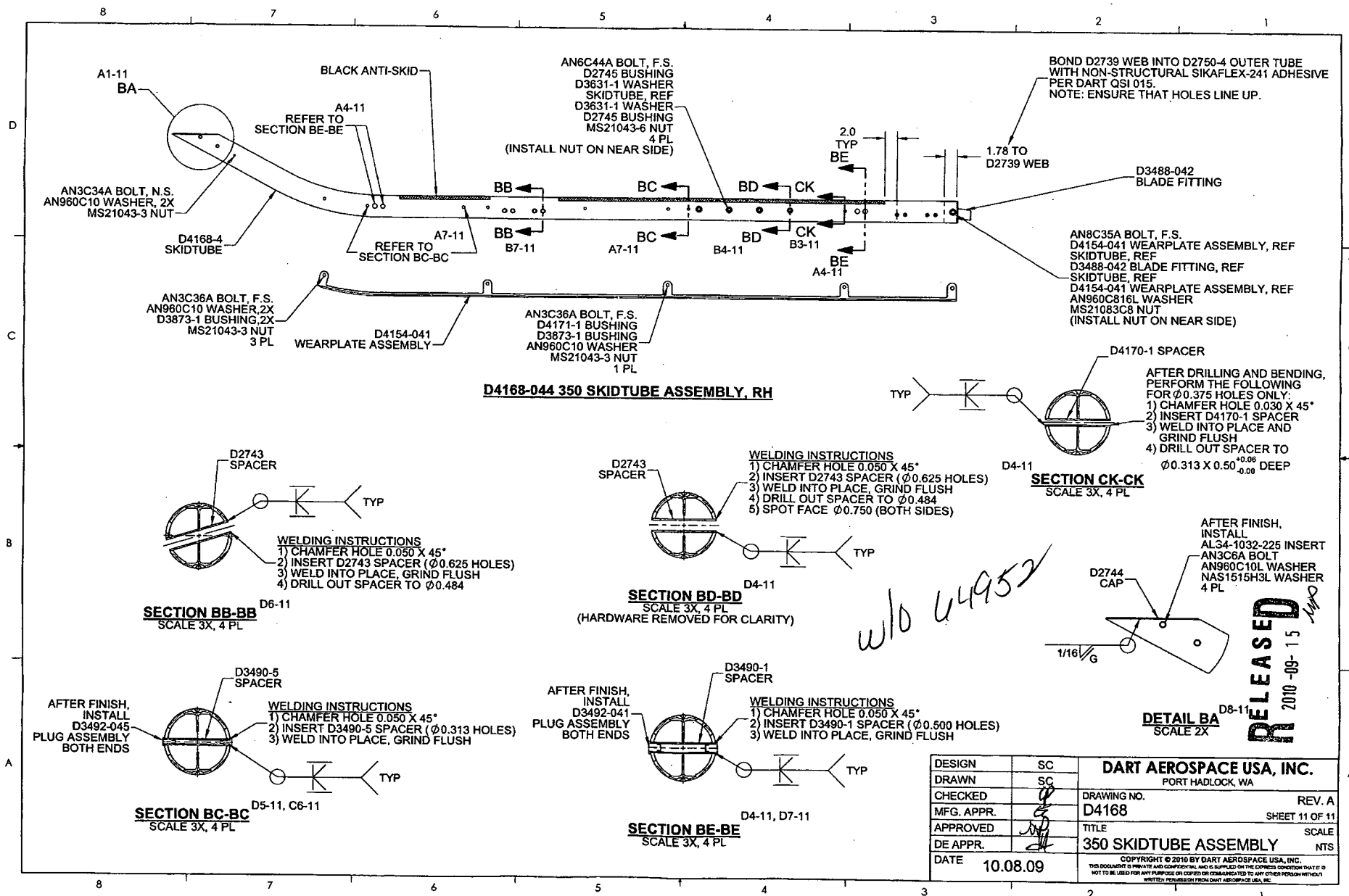
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8 7 6 5 4 3 2 1









NO. 243

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barkley Elliott
Job number: ~~64950~~ 64953
Part number: S350-636-016
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Salvador Date of Test Coupon 11-01-18

Welder Barkley Elliott Date of Test Coupon 11-01-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld